



Dart Aerospace Ltd.
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Canada

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D4491-042
Job Sheet 186491



Part No: D4491-042

Job Qty: 1 ea

Part Name: Door Hinge Assembly, Right Upper



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/16/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A SHEET 4 IPP REV:A NEW ISSUE 12-01-27 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/30/18	11/30/18	0.00	0.00	Start Up Stores/Pkg-1	6.91	NOV 22 2018
100	Packaging	1 pcs	11/30/18	11/30/18	0.00	0.00	Packaging1-5	6.91	NOV 22 2018
110	Small Fab	1 pcs	11/30/18	11/30/18	0.00	2.13	Small Fab-7	6.91	DAS
120	QC	1 pcs	11/30/18	11/30/18	0.00	0.00	QC5	6.91	38
130	Packaging	1 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3-2	6.91	DEC 11 2018
140	QC21-SA	1 Ea	11/30/18	11/30/18	0.00	0.00	QC21	6.91	DEC 11 2018

Part Op
Descriptions: 110 - ASSEMBLE AS PER DWG

21
9-89

DEC 03 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4491-2	Hinge, Right Upper	1 Ea (1 ea)	90-Start up Operation	F87818
D4492-1	Bushing	1 Ea (1 ea)	90-Start up Operation	F95290
D4493-1	Hinge Fork	1 Ea (1 ea)	90-Start up Operation	F89614
D4493-2	Hinge Fork	1 Ea (1 ea)	90-Start up Operation	F89615
D4520-1	Hinge Shim	1 Ea (1 ea)	90-Start up Operation	F713460
MS21043-08	Nut, Self-Locking	2 Ea (2 ea)	90-Start up Operation	F7130505
MS27039C0816	Screw	2 Ea (2 ea)	90-Start up Operation	F122815
NAS1149CN832R	Washer	4 Ea (4 ea)	90-Start up Operation	F5045862
POF-40022	Push-On Feet	1 pcs (1 ea)	90-Start up Operation	F120009

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4491-2	1	7	0
	D4492-1	1	8	0
	D4493-1	1	16	0
	D4493-2	1	14	0
	D4520-1	1	5	0
	MS21043-08	2	94	0
	MS27039C0816	2	36	0
	NAS1149CN832R	4	741	0
	POF-40022	1	190	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
NCR No. _____		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor

Root Cause		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐
Design ☐	Operator ☐	Bending ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐
Material ☐	Use for Testing ☐	Cuffs ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐
Past Expiry Date ☐	Manufacturing Process ☐	
Misidentified ☐	Past Due ☐	OTHER : ☐

Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Part: D4491 - 042
Job No: 186491
Serial No/Batch: S130515



Date: 11/22/18

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Part Specifications

Specifications could not be found.

Plex 11/16/18 10:08 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																			
Misidentified ☐	Past Due ☐																				